

SIX FLAGS NEW ENGLAND	
SUBJECT: CUTTING-WELDING-HOT WORKSPERMITS	SAFETY REFERENCE MANUAL
SECTION: 10	
EFFECTIVE: January 2016	SUPERSEDES: ALL PREVIOUS
CFR: 29 CFR 1910.251 - <i>Subpart</i> and 1926.52 - <i>Subpart D</i>	

10.1 PURPOSE

To establish a practical, efficient and reliable routine for inspecting, testing and controlling conditions necessary to make "hot work" safe. Hot work operations performed in areas not safely suited for such work can pose a serious fire hazard. For those times when hot work must be performed outside of a shop area, the hot work permit procedures should be adhered to.

10.2 OBJECTIVE

To maintain control over hot work operations, a written permit system will be utilized for all hot work operations performed away from established work areas. A permit will not be issued until ALL hazards are identified and controlled.

10.3 PROCEDURE

- A. Determination is made that welding/cutting needs to be done outside of a Maintenance Shop.
- B. A supervisor is contacted to issue a **HOT WORKS PERMIT**.
- C. The supervisor completes the Permit (Appendix A) or alternate multi part form and determines the expiration time of the Permit and if a Fire Watch is necessary.

Permits are valid for eight (8) hours, provided all conditions remain the same. If any condition changes, i.e., location, weather, job load, etc., a new Permit must be issued for each condition which has changed.

- D. The supervisor reviews all safety information with the welder/cutter and signs the Permit form. The supervisor keeps the top copy and gives the bottom copy to the welder/cutter.
- E. After completion of the job, the bottom copy of the Permit must be returned to the Safety Office.
- F. If there is any concern of fire after a job is completed, alert Security patrol to keep watch over the area.

10.4 SAFETY RULES

Verify that automatic sprinkler protection is in service in the affected area.

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Hot work equipment must be turned off when left unattended (breaks, lunch, emergencies, elsewhere, etc.), even though the fire watch remains at the site.

Covers placed over drains must be removed at the end of the work day or job completion.

When the job is completed or at the end of the work day, the permit is to be turned into the Security Dispatcher by the individual performing the work. If the hot work is not finished at the end of the day, a new permit must be obtained the next morning, or when the hot work is to resume. Security will turn in all completed permits to the Safety Department.

All employees who use welding equipment must have current and appropriate training to operate at SIX FLAGS NEW ENGLAND.

Never begin any welding or cutting without the proper permits - they are required.

Equipment must be rated for industrial use, be in good condition, and conform to the federal requirements governing application, installation, and operation of arc welding and cutting equipment.

Inspect all equipment before use. Valves, regulators, hoses, and torches should be thoroughly inspected. If any equipment is not in proper working condition, inform a supervisor and discontinue the job immediately.

Always check to see that appropriate fire protection equipment is immediately available before doing any welding or cutting. A portable fire extinguisher must be immediately available.

Refrain from using welding, cutting, or other hot work equipment in a building where sprinklers are out of service.

Move all combustibles at least 35 feet away from hot work operations. If combustibles cannot be moved, they must be protected by metal guards or by flameproof curtains or covers rather than ordinary tarpaulins. Wooden floors shall be wet down and covered with damp sand or fire resistant shields.

Hot work will be prohibited until responsible persons have been assigned to watch for dangerous sparks in the area and on floors above and below.

Arrange for a patrol of the area during breaks and at least one hour after work completed.

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10.5 PROTECTIVE CLOTHING

Welders shall wear the appropriate head and eye protection required by the work area. They shall wear appropriate welding helmets, long sleeve shirts, leathers, and welder's gloves. If grinding, chipping, or buffing is done, a face shield must be worn. If respirators are required, these shall be used.

At a minimum, fitters who are working with welders should wear long sleeve shirts, leather welder's gloves, and appropriately tinted eye goggles or glasses with side shields.

Welding hoods shall be checked periodically to assure that they are light tight.

10.6 FIRE WATCH

Fire watch shall be required whenever welding or cutting operations are performed in potentially hazardous or combustible locations where a fire could cause serious hazard. The following requirements are mandatory.

- A. Each individual selected to perform a Fire Watch shall be trained in how to conduct a fire watch, how to properly use extinguishing agents, how to call for help, and how to evacuate the area when necessary.
- B. The fire watcher cannot perform any other task that is not specifically related to the fire safety of the work area while on duty as a fire watcher. The fire watcher cannot leave the job site unless relieved by another fire watcher.
- C. Fire watchers shall have appropriate fire extinguishing equipment readily available.
- D. Fire watchers shall be familiar with the job site and procedures for sounding an alarm in the event of a fire.
- E. A Fire Watch shall be maintained prior to the start of hot work, during the hot work, and for at least one half hour after completion of the welding or cutting operation to detect and extinguish smoldering fires that are detected.
- F. If hot work is being performed inside of a confined space, the fire watch should maintain periodic communication with the worker(s) inside to make sure that they are safe from harm. If the worker(s) inside the confined space develop health problems and/or collapse, the attendant is to immediately call for help, BUT NEVER GO INSIDE THE CONFINED SPACE ALONE TO RESCUE THE

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WORKER(S). **NOTE:** See Confined Space Entry Program

- G. It is the responsibility of the person performing hot work operations to ensure that an attendant is provided before hot work begins.

10.7 ADDITIONAL SAFETY PRECAUTIONS

A. Cutting and Welding Equipment:

- Acetylene cylinders must be stored with valve caps in place and secured when in an upright position.
- Acetylene gas cylinder regulators must be set to regulate the gas pressure to torch at 15 psi or lower.
- Oxygen gas will be protected from oil, grease, fuels, etc. Cylinders, regulators, hose lines, etc., must be clean and oil free.
- Oxygen or acetylene must never be used to purge, blow-off, pressurize a line or container, or to power air driven tools.
- A flash arrestor (check valve) will be properly installed between the cylinder regulator and hose line on all oxygen and acetylene cylinders.
- Empty containers shall have their valves closed.
- ALL hot work must be done in compliance with the Hot Work Permit Policy.

B. Acetylene Generators:

- The space around the generator shall be maintained to ensure free, unobstructed operation and shall permit ready adjustment for charging.
- Relief valves shall be regularly operated to ensure proper functioning. Relief valves for generating chambers shall be set open at a pressure not in excess of 15 psig. Relief valves for hydraulic back pressure shall be set to open at a pressure not in excess of 20 psig.
- Non-automatic generators shall not be used for generating acetylene at pressures exceeding 1 psig, and all water flows shall be visible.

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HOT WORKS PERMIT

DATE: _____ **TIME:** _____

ISSUED TO: _____

DEPARTMENT: _____

WORK LOCATION: _____

The above location has been examined. The precautions checked as stated below on the permit have been taken to prevent fire. Permission is granted for this work.

PERMIT EXPIRES: (DATE) _____ **TIME:** _____

SIGNED: _____ **SHIFT #:** _____
Supervisor or Lead Employee

NECESSARY PRECAUTIONS

Before signing this permit authorizing a job, a supervisor or lead employee will inspect the proposed work area and check below the precautions taken:

- _____ Work area is outside and low risk for fire.
- _____ Sprinkler in service (if there are no sprinklers in building – write “NONE”).
- _____ Cutting and welding equipment in good repair.
- _____ Floors swept clean of combustibles.
- _____ Combustible floors wet down, covered with damp sand, metal or fire resistant sheets.
- _____ Flammable liquids removed, other combustibles protected with tarpaulins or metal shields
- _____ All drains, walls, and floor openings covered.

WORK PERFORMED ON WALLS AND CEILING

(tanks, containers, ducts, dust collectors, etc.)

- _____ Enclosed equipment cleaned of all combustibles.
- _____ Tank, containers, etc., to be purged of flammable liquids and or vapors.

FIRE WATCH

- _____ Fire Watch will be provided during and for 30 minutes after work has been completed.
- _____ An extinguisher and or hose line is on hand.
- _____ The person performing fire watch is fully trained in the use of equipment and sounding alarm.
- _____ Conditions do not warrant a fire watch.

I will inspect the area and all adjacent areas to which sparks and heat might have spread, including floors above and below and on opposite sides of walls. I will maintain an individual at the site for fire watch purposes, during the hot work operations and for at least 30 minutes after the work is completed. I will be certain areas are left in fire safe condition. I will turn in this permit to the on-duty security dispatcher at the end of hot work operations.

Security Officer **Signed** _____

Person Performing Work

White – Supervisor

Yellow – Welder/Cutter